



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW1205G00332-3G
Job Sheet 191300



8457

Part No: RBW1205G00332-3G

Job Qty: 1 pcs

Part Name: Main Gear Box Oil Draining Hose



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/26/19

Job Tracking No:

Due Date: 4/26/19

Created By: Marie Lajeunesse

Type: ~~SOLD~~ *SLH*

Description:

Note: DWG RBW1205G00332-3G Rev 6 IPP Rev A 18.02.15 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	4/26/19		0.00	1.33	Small Fab - 1		<i>MCC</i>
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	4/26/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
130	Packaging 3-1 - Stock - B4B	1 pcs	4/26/19		0.00	0.00	Packaging 3 - 1 - B4B		<i>DAS 28 9-89</i>
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S158925



Part: RBW1205G00332-3G

Job No: 191300

Serial No/Batch: S158925

Revision: 6

Inspector:

Exp Date:

Instructions:

Date: 03/05/19

DAS
40
9-89

MAR 06 2019

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					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	1 pcs	4/26/19	0.00 0.00		QC 21 - FG - 21	DAG
					QC 21 - FG - 70	21
					QC 21 - SA - 53	9-66 MAR 07 2019

Part Op 100 - Small Fab - 1-Cut 9657k135 (-25) spring to 0.5" as per work order deviation 2-Assemble as per DWG sheet 1.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location: _____
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
1315	Crimp Hose Clamp 9/16"	1 pcs (1 ea)	100-Small Fab - 1	5038400
2619	Spring Rnd 3/4"	1 Ea (1 ea)	100-Small Fab - 1	5075045
4464T123	O-Ring 9/16 Od X 1/16 Cross	1 Ea (1 ea)	100-Small Fab - 1	5048577
91665A350	Retaining Ring, 7/16" Shaft	1 Ea (1 ea)	100-Small Fab - 1	5046064
K010-0608	Hose Ø1/2 OD x Ø3/8 ID	6 ft (6 ea)	100-Small Fab - 1	5126670
RBW1205G00332-3G-01	Cap	1 pcs (1 ea)	100-Small Fab - 1	5137030
RBW1205G00332-3G-03	Quill	1 pcs (1 ea)	100-Small Fab - 1	5139008
RBW1205G00332-3G-17	Sleeve	1 pcs (1 ea)	100-Small Fab - 1	5136972
RBW1205G00332-3G-19	Barb	1 pcs (1 ea)	100-Small Fab - 1	5110398
RBW1205G00332-3G-21	Valve	1 pcs (1 ea)	100-Small Fab - 1	5137144
RBW1205G00332-3G-23	Screw (Modified B/O)	2 pcs (2 ea)	100-Small Fab - 1	5147938
RBW1205G00332-3G-24	End Cap	1 pcs (1 ea)	100-Small Fab - 1	5137017
9657K135	Spring	1 Ea (1 ea)	100-Small Fab - 1	5047612
M304TR0.375W.065	304 Round Tube .375 X .065W	.0830 ft (.083 ea)	100-Small Fab - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	1315	1	48	0
	2619	1	34	0
	4464T123	1	37	0
	91665A350	1	13	0
	9657K135	1	8	0
	K010-0608	6	345	0
	M304TR0.375W.065	0	57	0
	RBW1205G00332-3G-01	1	9	0
	RBW1205G00332-3G-03	1	13	0
	RBW1205G00332-3G-17	1	5	0
	RBW1205G00332-3G-19	1	11	0
	RBW1205G00332-3G-21	1	10	0
	RBW1205G00332-3G-23	2	3	0
	RBW1205G00332-3G-24	1	9	0

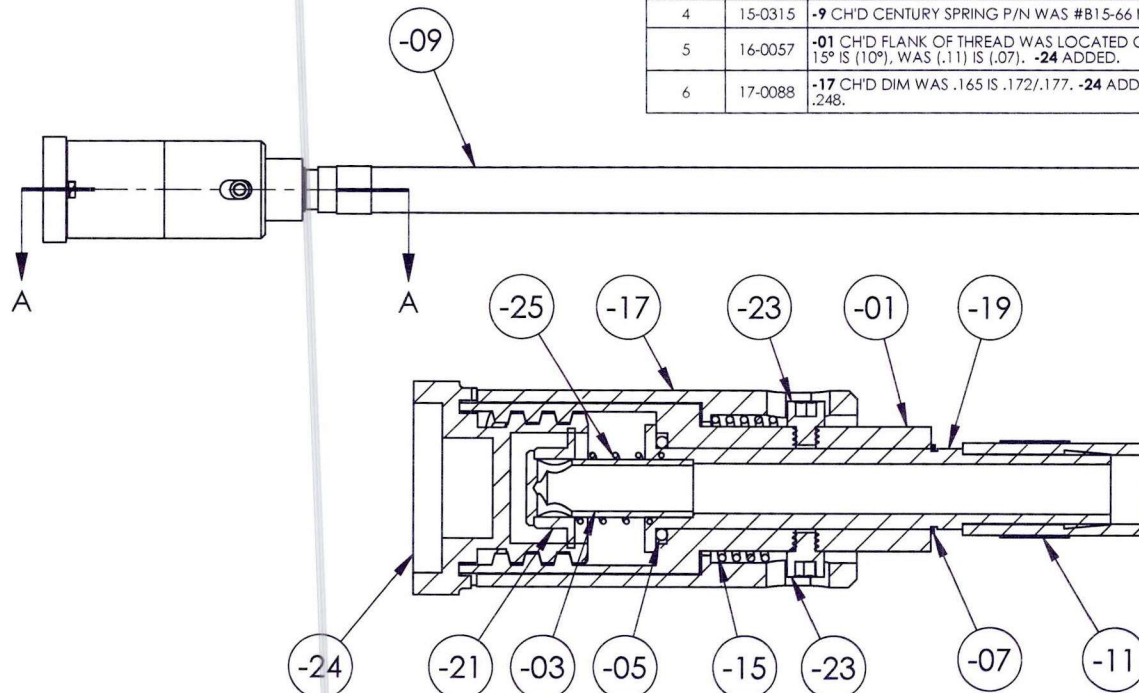
Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		REDESIGNED WITH SHUTOFF AND RETAINING SLEEVE, ADDED PARTS -03, -17, -19, -21 & -23.	3/2/2011	JAG	
2		-01 CH'D TO CLEAR ANODIZE, THREAD CORRECTED TO 13/16-6. -03 CH'D HOLE FROM Ø.20, CH'D LIMIT DIM FROM Ø.3135-.3139. -17 CH'D TO CLEAR ANODIZE. -19 CH'D HOLE DIA. FROM Ø.26 AND .10 FLANGE TO .06. -21 CH'D Ø.313 TO LIMIT DIM S.F.	11/30/2011	RJC	DW
3		-17 ADDED ENGRAVE NOTE. -23 CH'D O.D. FROM Ø.20 TO Ø.200 +.003 -.000.	2/15/2012	RJC	SE
3A		-13 DELETE, ENGRAVING IS ON -17.	5/2/2013	RJC	RJC
4	15-0315	-9 CH'D CENTURY SPRING P/N WAS #B15-66 IS #2619.	9/30/2015	RJC	JAG
5	16-0057	-01 CH'D FLANK OF THREAD WAS LOCATED ON CENTERLINE IS OFFSET 13° FROM CENTERLINE; WAS 15° IS (10°), WAS (.11) IS (.07). -24 ADDED.	6/16/2016	SM	JAG
6	17-0088	-17 CH'D DIM WAS .165 IS .172/.177. -24 ADDED DIM'S .696, Ø1.09, MIN. R. DELETED DIM'S 2X .068, .248.	4/17/2017	RJC	JAG



SECTION A-A
SCALE 1 : 1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 191300 M.C.S
19-02-26

NOTE:
FUNCTION: PART OF HELICOPTER SERVICING KIT PART No 3G1205G00131. USED TO DRAIN OIL FROM THE MGB THROUGH THE PARKER STRATOFLEX COUPLING, RBW1205G00332-3G REPLACES STRATOFLEX (11362) (A3Q07) P/N 165006.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-01	1	CAP	6061		2
			-03	1	QUILL	303/304 S.S.		3
		B/O	-05	1	O-RING	BURNA-N	9/16 OD X 1/16 CROSS (MCMaster-CARR #4464T123)	1
		B/O	-07	1	EXTERNAL RETAINING RING	SPRING STEEL	Ø7/16 SHAFT MCMaster-CARR #91665A350	1
		B/O	-09	1	HOSE	VINYL	Ø1/2 X 3/8 X 6 FT. KURI-TECH #K010-0608	1
		B/O	-11	1	CRIMP HOSE CLAMP	S.S.	Ø1/2 DIXON VALVE #OET-1315	1
		B/O	-15	1	SPRING	SPRING STEEL	Ø3/4 CENTURY SPRING #2619	1
			-17	1	SLEEVE	6061		4
			-19	1	BARB	303/304 S.S.		5
			-21	1	VALVE	303/304 S.S.		6
			-23	2	SCREW	S.S.	6-32 X 1/8 (MCMaster-CARR #92196A139) MODIFIED	7
			-24	1	END CAP	6061		8
		B/O	-25	1	SPRING	MUSIC WIRE	Ø.028 WIRE: Ø.360 OD X .5 FREE LENG RIED #S1165	1

DART
AEROSPACE

TITLE
MAIN GEAR BOX DRAIN TOOL

DWG NO. **RBW1205G00332-3G**

REV
6

MAT'L
HEAT TREAT
FINISH
SPEC
DRAWN BY: PERRITT
CHECKED: DUERFELDT
OPPS APPR: ANDERSON
QA APPR: LINDSAY
APPROVED: GILBERT

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS ± 1/8
.XX ± .01 ANGLES ± 5°
.X ± .1 SURFACES = 125/√

1. BREAK ALL SHARP EDGES
.015 x 45° OR .015R
2. DIMENSIONAL LIMITS APPLY
AFTER PLATING
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

USED ON MODEL
AGUSTA

SCALE 1:2 DATE 2/23/2011 SHEET 1 OF 8

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No. _____

Route update only ☐

Job: _____ Part No. <u>RBW1205G00132-3G Rev. 9</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐																															
Date: _____		Sequence #: _____		QTY Affected: _____		MRS (Q91042) <i>M. Lee</i> Oct 30, 2018																													
Description Work Order Deviation				Disposition																															
Kuri-Tech Hose (K010-0608) easily pulls out of Coupling (McMaster Carr 51495K116)				Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel into one end of the Kuri-Tech Hose until flush.																															
				Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable).																															
				This deviation is acceptable.																															
The fit, form and function of the part will be as originally intended.				Completed By Lead hand / Supervisor QC / QA Coordinator																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☒ X Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Follo/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>						☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Follo/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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